

Work Order ID 68153

Thursday, April 07, 2011 8:40:55 AM

Page 1

Item ID: D4327-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Angle

Start Date: 4/7/2011 Start Qty: 2.00

Required Date: 4/8/2011 Req'd Qty: 2.00

Cust Item ID:

Customer:

ASAP

Reference:

Approvals:

Process Plan: MFDate: 11-04-07 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4327

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

B11-4-7

(3)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-4-7

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S. Subalox

(23)

124



Small Fab

Memo

0.00

Small Fab

Form as per dwg

0.00

Srs Subalox

(2)

870

126



QC

QC5 inspect
Memo

0.00

Quality Control

0.00

S. Subalox

(72)

W/O: 68153		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11-24-07	124	Keep 1 pc for template	SS	11/24/07	1	✓ 11-24-07	

Part No: D4327-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68153

Thursday, April 07, 2011 8:40:55 AM

Page 4

Item ID: D4327-3

Accept

Revision ID:

Item Name: Angle

Start Date: 4/7/2011 Start Qty: 2.00

Required Date: 4/8/2011 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/4/8

MF
11-04-07

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, April 07, 2011 8:40:51 AM

Page 1

Work Order ID: 68153



Parent Item: D4327-3



Parent Item Name: Angle

Start Date: 4/7/2011

Required Date: 4/8/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.04.04 new issue DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.040

Purchased

No

100

sf

130.5000

0.398

0.837895



B 11-3A7

2024-T3 :040 sheet

Location

Loc Qty

Loc Code

MAT022

130.5

112291

2.5

112331

64

113162

64

112291

③

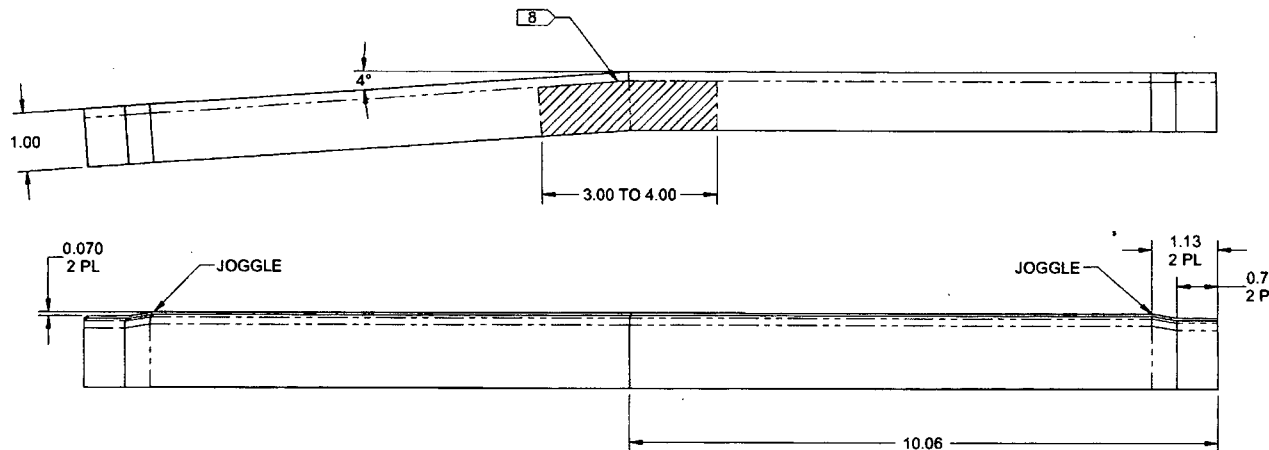
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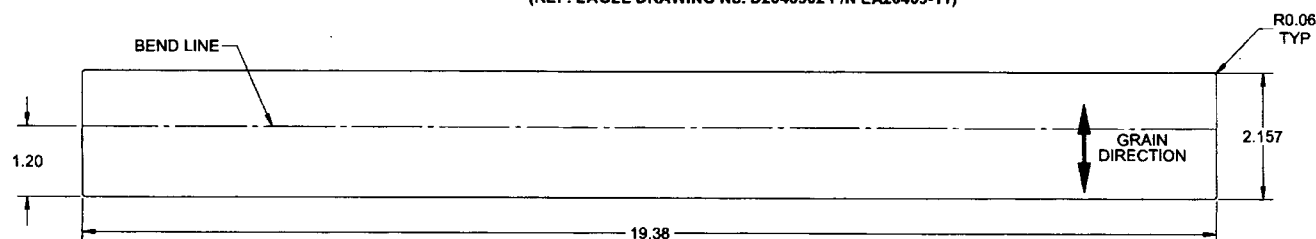
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NOTE: Date & initial all entries







D4327-1 ANGLE
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-11)



D4327-1F FLAT PATTERN
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-11)

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
PER DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.17 lbs
- 8) SHRINKING AREA TO SUIT DT9753 TEMPLATE

A		NEW ISSUE		RF	10.11.22
REV.	DESCRIPTION			BY	DATE
DESIGN	RF	<div>DART AEROSPACE LTD</div> <div>HAWKESBURY, ONTARIO, CANADA</div> <div>DRAWING NO. D4327</div> <div>TITLE VRD PARTS</div> <div>COPYRIGHT © 2010 BY DART AEROSPACE LTD</div> <div><small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small></div>			
DRAWN	RF				
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.					
DATE	10.11.22				

RELEASED
2011-04-06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			





NOTE: Date & initial all entries

D4327-3 ANGLE
(MAKE FROM D4327-3F FLAT PATTERN)
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-7)

D4327-3F FLAT PATTERN
(REF. EAGLE DRAWING No. D2046902 P/N EA20469-7)

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
QQ-A-250/4 OR AMS-QQ-A-250/4
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OR ASTM B209
PER DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.21 lbs
- 8) FORM TO SUIT DOOR PROFILE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4327	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		VRD PARTS	NTS
DATE	10.11.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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RELEASED
2011-04-06

#68153

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